

Work Order ID 68773

Thursday, April 21, 2011 8:47:05 AM



Page 1

Item ID: D3571-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Guide

Start Date: 4/20/2011 Start Qty: 7.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 7.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-01-21

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3571	Rev A								

100

0.00



BAND SAW

0.00

Bandsaw

Memo

Jeaspa Bandsaw

Cut blank 2.90 " long

enR 11/04/27

7

[Signature]

110

0.00



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

HAAS CNC vertical machine #1

1- Mill as per Folio FA681 Rev: AA & Dwg D3571 Rev: A ☐ 2-Deburr
per dwg D3571

enR 11/04/28

7

[Signature]

120

0.00



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

Quality Control

enR 11/04/28

7

[Signature]

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68773

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Page 2

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Revision ID:

Stop



Item Name: Guide

Start Date: 4/20/2011 Start Qty: 7.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 7.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	J.F.S.	11/04/29		7	Ø		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				7	BL	11-5-2	
150 Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 M115128 Memo START TIME: 1:55 FINISH TIME: 2:25	0.00 0.00				7	BL	11-5-2	

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Work Order ID 68773

Thursday, April 21, 2011 8:47:05 AM



Page 3

Item ID: D3571-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Guide

Start Date: 4/20/2011 Start Qty: 7.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 7.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				7	0	11/05/12	
170 Packaging Packaging	Identify as per dwg & Stock Location: 245 Memo	0.00 0.00						11/5/12	5/17
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						11/5/30	

11-05-3
G

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, April 21, 2011 8:47:13 AM

Page 1

Work Order ID: 68773

Parent Item: D3571-3

Parent Item Name: Guide



Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 7.00

Required Qty: 7.00

Comments: IPP Rev:A New Issue 07-02-01 JLM
IPP Rev:B Remove manual Machinig 08-05-26 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X01.50 0		Purchased		No		110	f	37.3420	0.241	1.775789			



6061-T6 Bar .750 X 1.50



Location

Loc Qty

Loc Code

MAT003

37.342

→ 116405

16.6

116604

1.5

116623

19.242

1.776 on 11/04/27

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	68773
Description: Guide		Part Number:	D3571-3
Inspection Dwg: D3571 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.698	+/-0.010	.699	—		Vern ML-7	
2.75	+/-0.030	2.750	—		"	
1.38	+/-0.030	1.375	—		"	
1.25	+/-0.030	1.250	—		"	
0.63	+/-0.010	.625	—		"	
0.031 chamfer	+/-0.010	.035	—		"	
Ø0.500	+0.006/-0.001	Ø.501	—		"	
Ø0.201	+0.005/-0.001	Ø.203	—		"	
R0.25	+/-0.030	R.253	—		Red gage	
0.260	+0.000/-0.010	.253	—		Vern ML-7	
Ø0.385 x 100°	+0.006/-0.001 x 0.5°	Ø.385 x 100°	—		"	
0.125	+/-0.010	.125	—		"	
2.250	+/-0.010	2.243	—		"	
0.250	+/-0.010	.255	—		"	
0.188	+/-0.010	.189	—		"	
0.063 chamfer	+/-0.010	.063	—		"	

Measured by:	cm	Audited by:	J.F.S	Prototype Approval:	N/A
Date:	11/04/28	Date:	11/04/29	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.16	New Issue	KJ/JLM	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

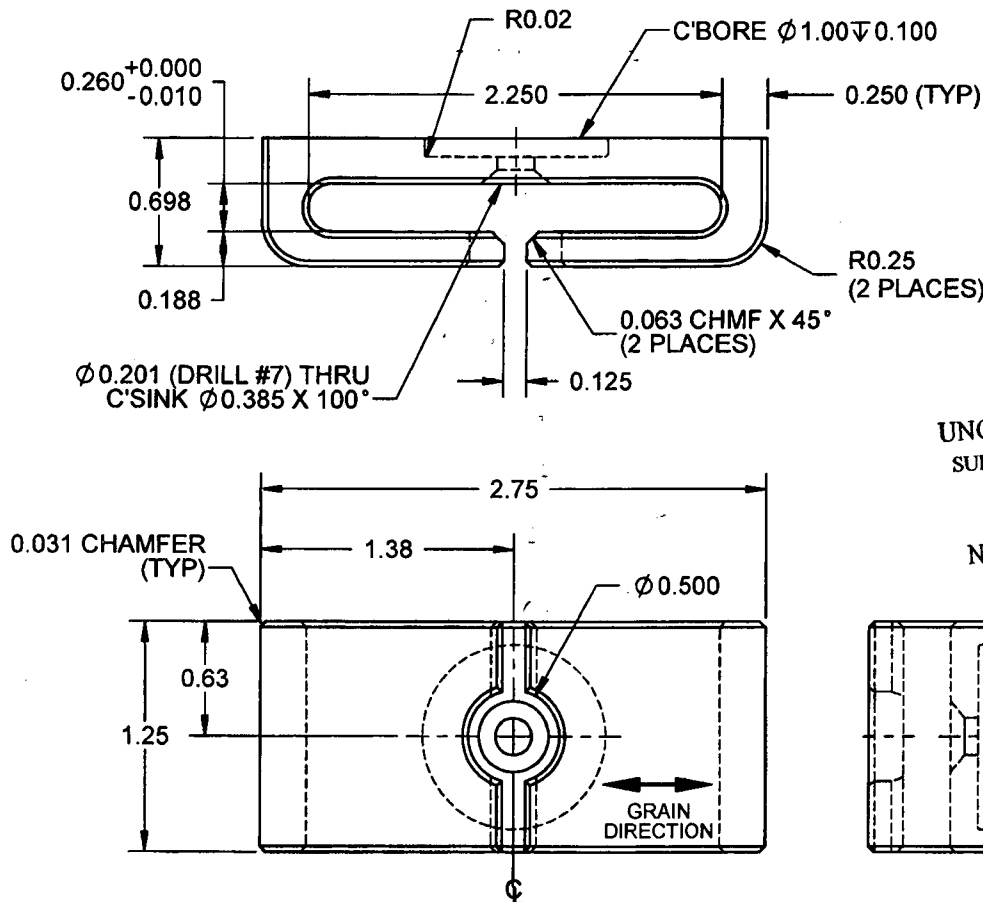
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART

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DATE 07.01.29	TITLE GUIDE	SCALE 1:1	
REV A	DATE 07.01.29	DESCRIPTION NEW ISSUE	

RELEASED07.04.12 *[Signature]*

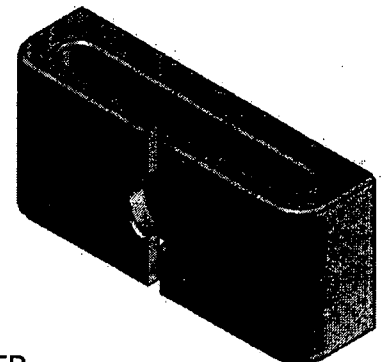
SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *68773*

*P/11-04-21***D3571-1 GUIDE****NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3571-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT ϕ

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

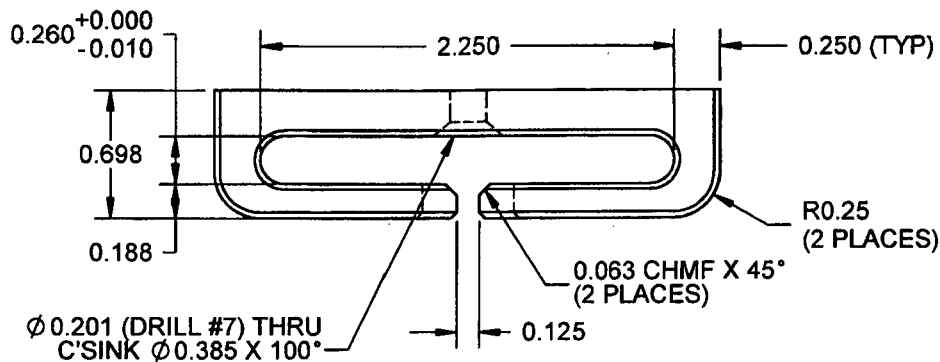
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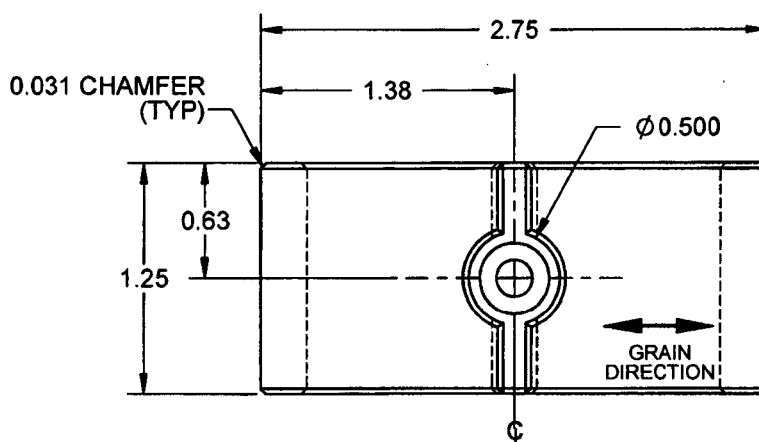


DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>CH</i>	DRAWING NO. D3571	REV. A
DATE 07.01.29		TITLE GUIDE	SHEET 2 OF 2 SCALE 1:1

RELEASED
07.04.12 *[Signature]*



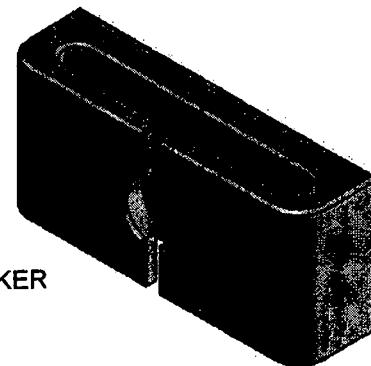
u/068773



D3571-3 GUIDE

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PER QQ-A-225/8 OR AMS 4117/4128/4115/4116
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- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT ϕ



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